

Work Order ID 98139-2

Thursday, March 07, 2013 1:53:57 PM

\*98139\*

Page 1

Item ID: D4529-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Horizontal Swing Arm

Start Date: 3/7/2013 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 3/8/2013 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 13-3-07

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4529

A

100

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

110

\*110\*

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

0.00

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

SCRAP

Part scrap  
5/3/12

S/S  
12/23/11

PTD  
(2 pages)

1 FF 13-03-11

23

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**\*98139\***

Page 2

Item ID: D4529-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Horizontal Swing Arm

Start Date: 3/7/2013 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 3/8/2013 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*pkg in  
CA please*

*mf  
13-3-12*



NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: dat Date: 13/04/11QA Closed: OK Date: 13/3/210

Work Order: <u>98139-2</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D1529-041</u>		Skid-tube <input type="checkbox"/>	Cross-tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2399</u>		Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data				1 part hole was over size when removed the rivet  R.C process	16 2-8 052042 13/3/12	Scrap - do this No replace	FF 13-03-11	DAS 16 2-8 13/3/12	DAS 16 2-8 13/3/12 052042
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

## FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

# Picklist Print

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Page 1

Work Order ID: 98139

Parent Item: D4529-041

Parent Item Name: Horizontal Swing Arm

Start Date: 3/7/2013

Required Date: 3/8/2013

Start Qty: 2.00

Required Qty: 2.00

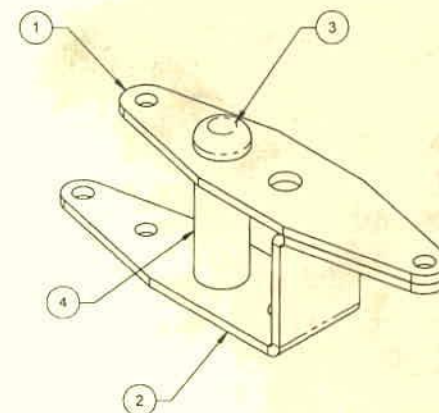
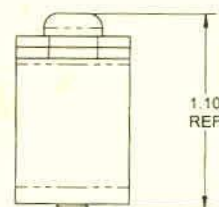
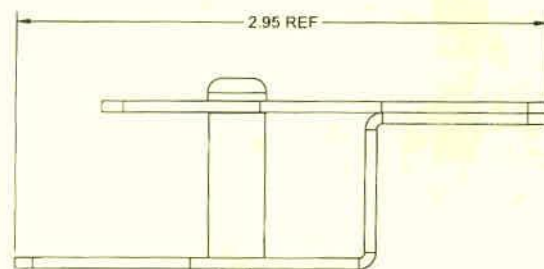
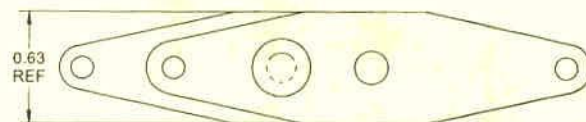
Comments: IPP REV:A NEW ISSUE 12-01-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4529-3 Horizontal Swing Arm, Lower		Manufactured	No			100	Each	2.0000	1	2		SM 13/03/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2							
				89867		2							
MS20613-5C18 RIVET		Purchased	No			100	Each	47.0000	1	2		SB 13/03/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST312		47							
				120753		47							
D4529-1 Horizontal Swing Arm, Upper		Manufactured	No			100	Each	0.0000	1	2		SB 13/03/11	
NAS42DD552FC SPACER		Purchased	No			100	Each	21.0000	1	2		SB 13/03/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST275		21							
				120250		21							





ITEM	QTY	P/N	DESCRIPTION
	X	D4529-041	HORIZONTAL SWING ARM
1	1	D4529-1	HORIZONTAL SWING ARM, UPPER
2	1	D4529-3	HORIZONTAL SWING ARM, LOWER
3	1	MS20613-5C18	RIVET
4	1	NAS42DD552FC	SPACER



**D4529-041 HORIZONTAL SWING ARM**

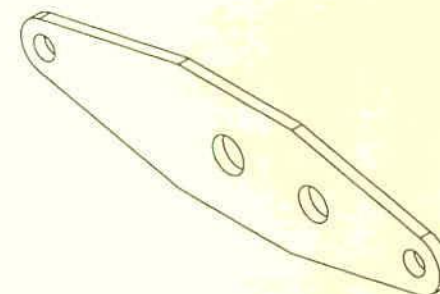
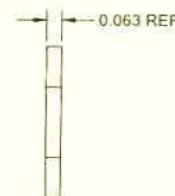
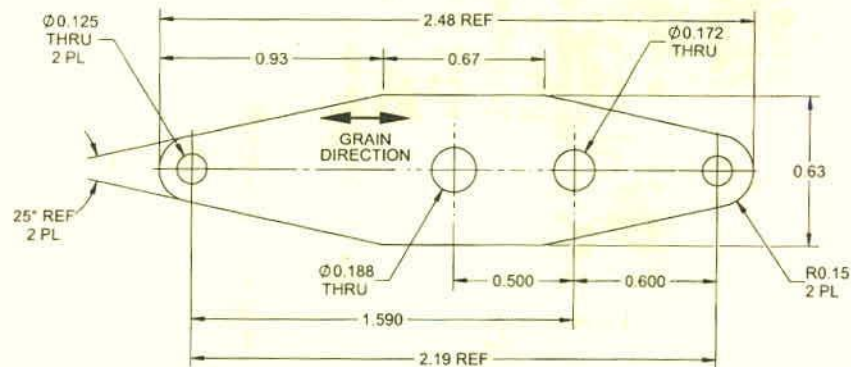
NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7  
 7) WEIGHT: 0.07 lbs

**RELEASED**  
 2012-03-08

A	NEW ISSUE	RP	12.02.24
REV	DESCRIPTION	BY	DATE
DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4529	SHEET 1 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	HORIZONTAL SWING ARM	NTS
DATE	12.02.24	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	







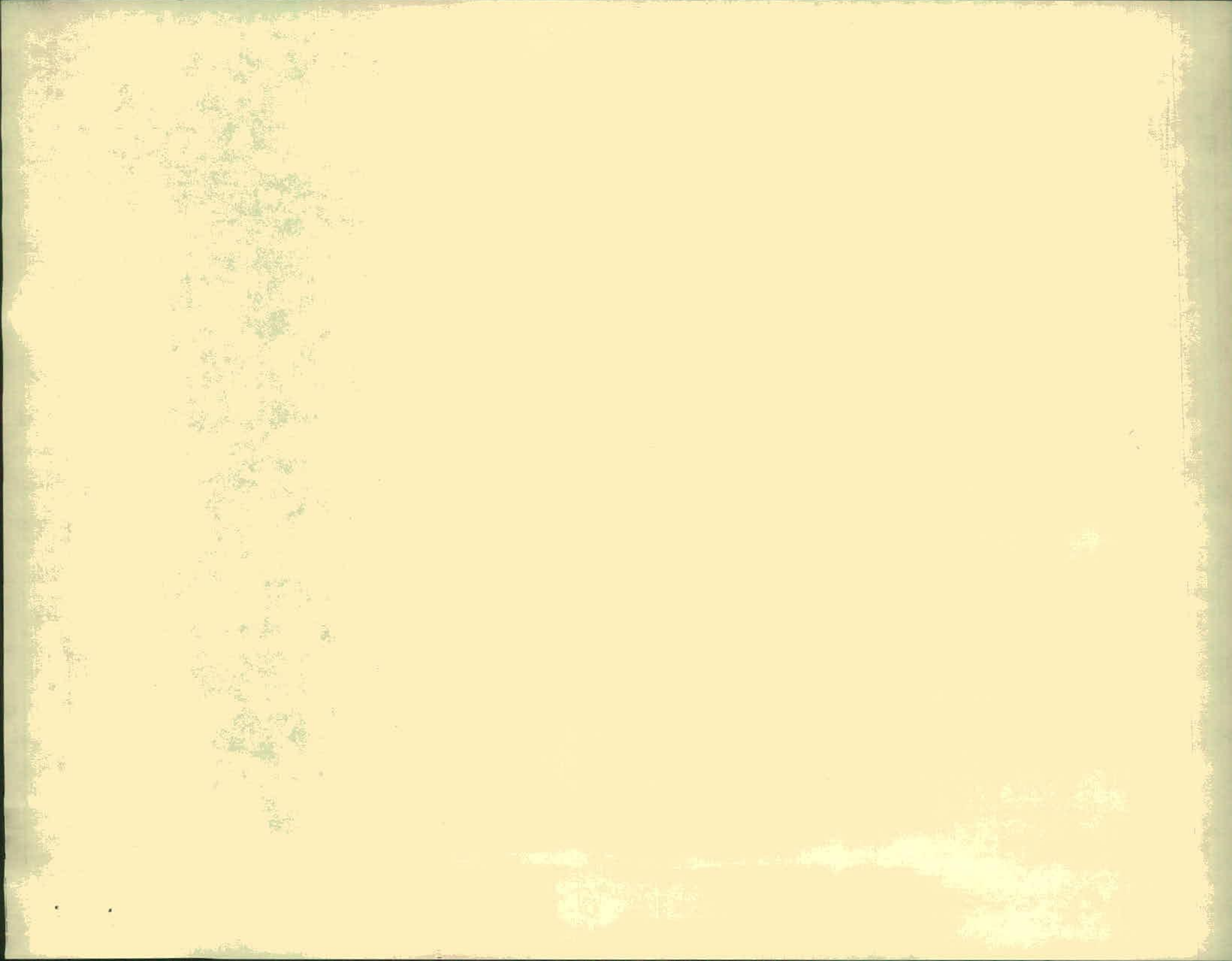
**D4529-1 HORIZONTAL SWING ARM, UPPER**

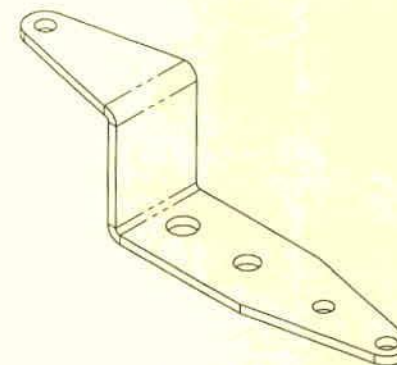
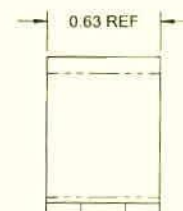
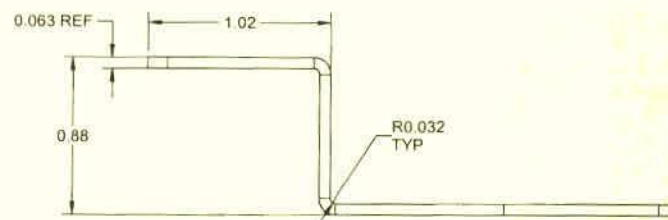
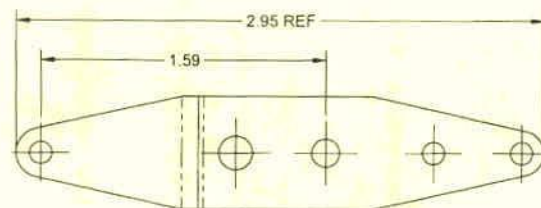
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2012-03-08

**NOTES:**

- 1) MATERIAL: 304/316 SS SHEET, ANNEALED, 2B FINISH PER MIL-S-5059 OR AMS 5513 (304) OR AMS5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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APPROVED		TITLE	SCALE
DE APPR.		HORIZONTAL SWING ARM	NTS
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**D4529-3 HORIZONTAL SWING ARM, LOWER**  
(MADE FROM D4529-3F)

**RELEASED**  
R 2012-03-08 D

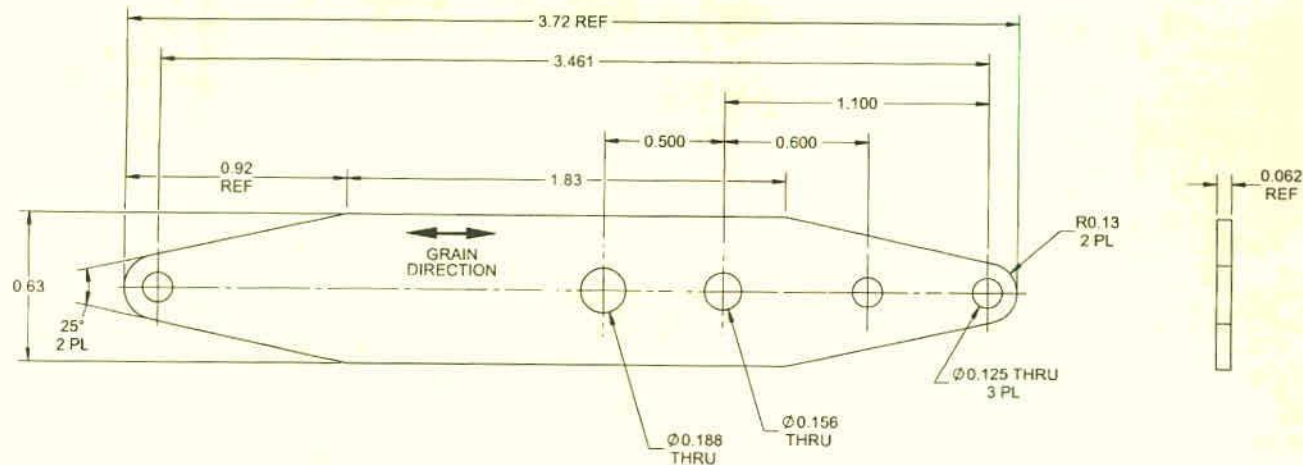
**NOTES:**

- 1) MATERIAL: 304/316 SS SHEET, ANNEALED, 2B FINISH PER MIL-S-5059 OR AMS 5513 (304) OR AMS5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4529</b>	SHEET 3 OF 4
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DE APPR.	<i>[Signature]</i>	<b>HORIZONTAL SWING ARM</b>	NTS
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**D4529-3F HORIZONTAL SWING ARM, LOWER (FLAT PATTERN)**

**NOTES:**

- 1) MATERIAL: 304/316 SS SHEET, ANNEALED, 2B FINISH PER MIL-S-5059 OR AMS 5513 (304) OR AMS5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	AP	D4529	SHEET 4 OF 4
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